

State of Illinois
Illinois Department of Transportation

Addendum
MANUAL FOR FABRICATION OF PRECAST PRESTRESSED CONCRETE
PRODUCTS

Effective: August 7, 2009

Page 2 Introduction, 11th paragraph. Delete paragraph including associated bullet points and last sentence after bullet points.

Page 2 Introduction, 8th and 9th paragraph. Revise the paragraphs and add a new paragraph in between the 8th and 9th paragraphs to read:

“All plants fabricating prestressed concrete products for state funded projects shall be inspected by the Department (District and/or BMPR) and shall meet Department Specifications. All plants fabricating prestressed concrete products for state funded projects shall also be certified under the cooperative “Precast/Prestressed Concrete Institute (PCI) and Government Agency Certification Program” (PCI Plant Certification Program). (Note: A Producer shall meet these two requirements even if they subcontract the entire project to another Producer who meets these requirements.) Producers who manufacture only deck beams (straight strands) shall be PCI Certified as PCI B3-IL. Producers who manufacture beams with harped strands (I and bulb T) shall be PCI Certified as PCI B4-IL. A Producer who is Certified as PCI B4-IL is automatically Certified as PCI B3-IL. PCI approval of a Quality System Manual (QSM) with Department review and comment is an integral part of the PCI Certification Program. A Producer’s QSM shall be developed, maintained and revised as necessary according to “Preparation Guidelines for a Structural Plant Quality System Manual” (QSM-1) which is published by PCI. Appendix IL in QSM-1 shall be used in conjunction with the main body of the document to fulfill the QSM requirements of the PCI Certification Program.

To receive the B3-IL or B4-IL Certification from PCI, the Producer shall have their Quality System Manual approved by PCI and their plant audited by PCI. Upon completion of a successful audit, PCI will issue the B3-IL or B4-IL Certification to the Producer. Since it is desired by PCI to audit work being done for the Department, the Department will permit a Producer to begin manufacture of Department products after approval of the Quality System Manual by PCI and Department (District and/or BMPR) inspection of the Producer’s plant shows that it meets Department Specifications. It is also required that the PCI approved Quality System Manual be delivered to the District responsible for the Quality Assurance inspection and the Bureau of Materials and

Physical Research before start of production. Delivery may be through electronic means or other suitable methods. Once production has started for a Department project, the Producer will have 150 calendar days from the start of production to pass the audit and obtain B3-IL or B4-IL Certification from PCI. Failure to obtain PCI B3-IL or B4-IL certification within this time frame will prevent the Producer from starting any work let after the 150 calendar days. When the Producer passes the audit, this restriction will be removed. Work let prior to expiration of the 150 calendar days may be started and completed for the Department.

Producers shall make the findings of all PCI Audits related to PCI B3-IL or PCI B4-IL Certification available to the Department. This information shall be submitted to the District or the Bureau of Materials and Physical Research, whichever entity is responsible for the Quality Assurance inspection. This includes the total grade for each division and the overall total grade given to a Producer by PCI Auditors. Producers shall notify Department personnel of and permit them to attend audit "close-out" meetings with PCI Auditors when discussions pertain to PCI B3-IL or PCI B4-IL Certification."

Page 7 Section 1.2.2 Quality System Manual, 1st, 2nd and 3rd paragraphs. Revise the 3 paragraphs to be 4 paragraphs to read:

"The Producer shall develop, maintain and revise a Quality System Manual (QSM) according to "Preparation Guidelines for a Structural Plant" (QSM-1) which is published by PCI. Appendix IL in QSM-1 shall be referred to in conjunction with the main body of the document to fulfill the QSM requirements of the Department and PCI.

The Producer shall initially submit a QSM to the District responsible for inspection and the Bureau of Materials and Physical Research (BMPR) for review and comment. Most of the comments on a Producer's QSM from the District and BMPR shall be addressed by the Producer before submittal of the QSM to PCI. If any additional comments from the Department are required, they will be forwarded to PCI by BMPR as part of the official Departmental letter of review completion delivered by electronic or other suitable means. Once the Departmental review process is completed, the Producer is responsible for submitting the revised QSM to PCI for further review and approval.

After a Producer's QSM has been approved by PCI, approved copies (with Signature Page) shall be delivered to the District responsible for inspection and BMPR by electronic or other suitable means. The source of delivery may be PCI or the Producer. The District and BMPR will keep a copy of any discontinued QSM for a minimum of three years.

Construction of Department precast prestressed products shall not begin until approval of the QSM by PCI and Department inspection (District and/or BMPR) of the Producer's plant shows that it meets Department Specifications (see also the Introduction to this manual)."